

Date: Monday, 7/30/2007 1:52:42 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 33786	
Estimate Number : 11124	
P.O. Number : <i>N/A</i>	Part Number : <i>D3403-1</i> <del>D3403-3</del> <i>RU</i>
This Issue : 7/30/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3403 REV B <i>07-09-10</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33562	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/15/2007 Qty: 100 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A 05.08.31 New issue KJ/JLM Est Rev:B 06-03-07 As per Rev B JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.2080 f(s)/Unit Total : 20.8000 f(s)  
Material: AISI 303 SS Bar Ø0.750  
(M303R0.750)  
Identify for D3403-1  
Batch: *M105145* *1326*

*2IP 07/09/06*

*104973 10.48*  
*20 07/09/08-09*

*23.74' overall length used.*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1- Turn as per Folio FA556 & Dwg D3403  
Folio Rev: *AA* Dwg Rev: *B*

2-Deburr

*20 07/09/08-09*

*(P10) →*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*20 07/09/08-09*

*(113)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*2.1 07/09/10*

*(113)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*20 07/09/12* *(130)*

*130*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 07/09/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	#2.0	22 Parts are 0.060" too short in length. P.C. array set up for short parts.	PH per QSI out 07.09.10	cut parts shorter to make D3403-3 (Custom w/o to use these parts)	PH per QSI out 07.09.10	KL 34569	PH per QSI out 07.09.10	SW 07/09/10

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33786

Part Number: D34031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



138

Comment: FINAL INSPECTION/W/O RELEASE

12/07/09/15

Job Completion



U 07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

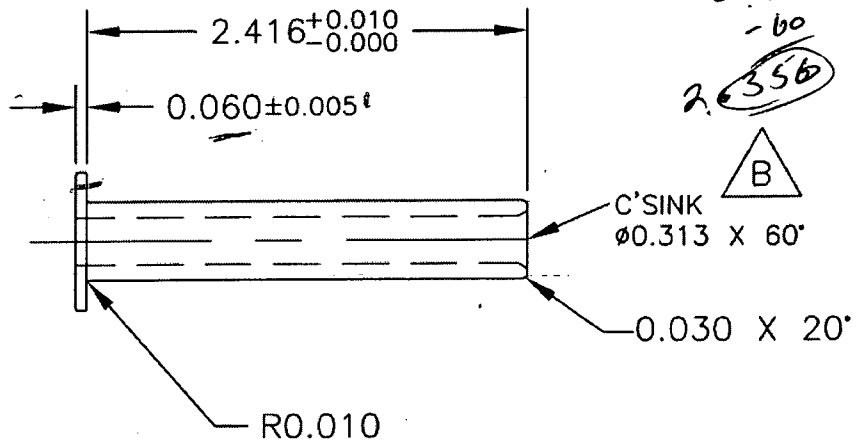
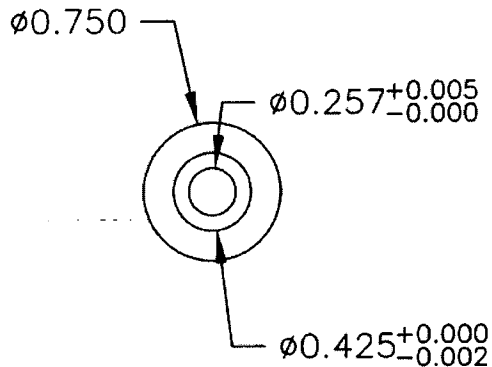
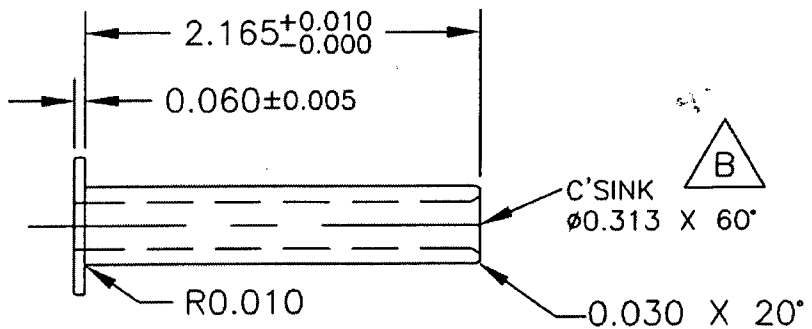
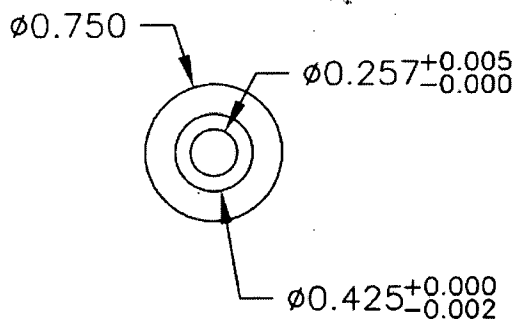


**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3403	REV. B SHEET 1 OF 1
DATE 06.01.23		TITLE BUSHING	SCALE 1:1
A	05.03.07	NEW ISSUE	
B	06.01.23	ADD COUNTERSINK	

**RELEASED**

06.01.27 H

**D3403-1 BUSHING****D3403-3 BUSHING****D3403-1/-3 BUSHING**

- 1) MATERIAL: Ø0.750 AISI 303 ROUND BAR (REF. DART SPEC. M303R0.750)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
- 4) ALL DIMENSIONS ARE INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33786

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